

split up
SB 07/10/02

Date: Thursday, 10/08/2006 10:01:19 AM
User: Linda Lacelle

Process Sheet

| | | | | | | | | |
|-----------------------|---|------------------|-------------------------------|--|--|--|--|--|
| Customer | : CU-DAR001 Dart Helicopters Services | Drawing Name | : N1 GEARBOX ACCESS PANEL KIT | | | | | |
| Job Number | : 28124 | Part Number | : D3255041 | | | | | |
| Estimate Number | : 12503 | Drawing Number | : D3255 REV B | | | | | |
| P.O. Number | : N/A | Project Number | : N/A | | | | | |
| This Issue | : 10/08/2006 | S.O. No. | : N/A | | | | | |
| Prsh't Rev. | : NC | Drawing Revision | : B | | | | | |
| First Issue | : N/A | Material | : N/A | | | | | |
| Previous Run | : N/A | Due Date | : 31/08/2006 | | | | | |
| Written By | : | Qty: | 4 | | | | | |
| Checked & Approved By | : | Um: | Each | | | | | |
| Comment | : Est Rev:C Removed Manufacturing of D3255-1/-2/-3 06-08-02 | | | | | | | |
| | JLM | | | | | | | |

Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : | |
|---------|-----------------------|---|---------------------|
| 1.0 | D32551 | Panel | |
| | | Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) | |
| | | Panel Batch: B28837 | |
| 2.0 | D32553 | Cap | |
| | | Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) | |
| | | Cap Batch: M21863 | |
| 3.0 | LARGE FAB 1 | LARGE FABRICATION RESOURCE 1 | |
| | | Comment: LARGE FABRICATION RESOURCE 1 | |
| | | 1-Weld as per Dwg D3255 A/R SS ROD Batch: M105138 | (4) |
| | | 2-Grind Welds Flush | |
| 4.0 | QC5/9 | WELD INSPECTION | |
| | | Comment: WELD INSPECTION | PD 07-10-01 (4) |

| W/O: | | WORK ORDER CHANGES | | | | | |
|----------|------|--------------------|----|----------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| 07/10/02 | 8 | Split into | SB | 07/10/02 | 3 | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/10/11
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Thursday, 10/08/2006 10:01:19 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: N1 GEARBOX ACCESS PANEL KIT

Job Number: 28124

Part Number: D3255041

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|--|
| 5.0 | POWDER COATING | POWDER COATING <i>M104846</i> |
| 6.0 | QC3 | INSPECT POWDER COAT/CHEMICAL CONVERSION <i>M-F 07/10/02</i> |
| 7.0 | D32555 | Gasket <i>B26136 x 2mx, B28839 x 2mx</i> |
| 8.0 | SMALL FAB 1 | SMALL & MEDIUM FAB RESOURCE 1 <i>SB 07/10/03</i> |
| 9.0 | QC5 | INSPECT WORK TO CURRENT STEP <i>5 07/10/03 (X3)</i> |
| 10.0 | PACKAGING 1 | PACKAGING RESOURCE #1 <i>7/10/10 SP (3x)</i> |
| 11.0 | DC | DOCUMENT CONTROL <i>207/10/11 (3)</i> |

Job Completion



W 07-10-10

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |

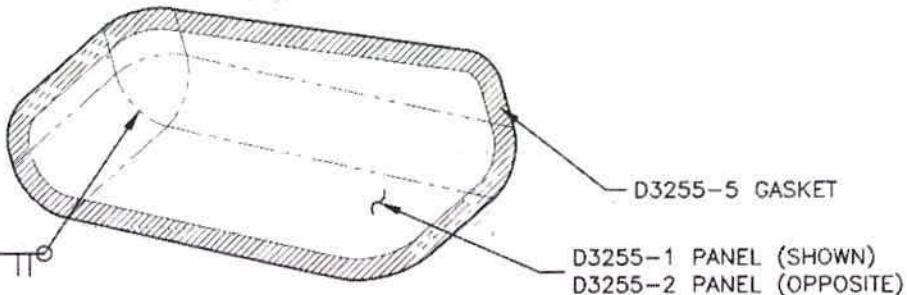
NOTE: Date & initial all entries

DART

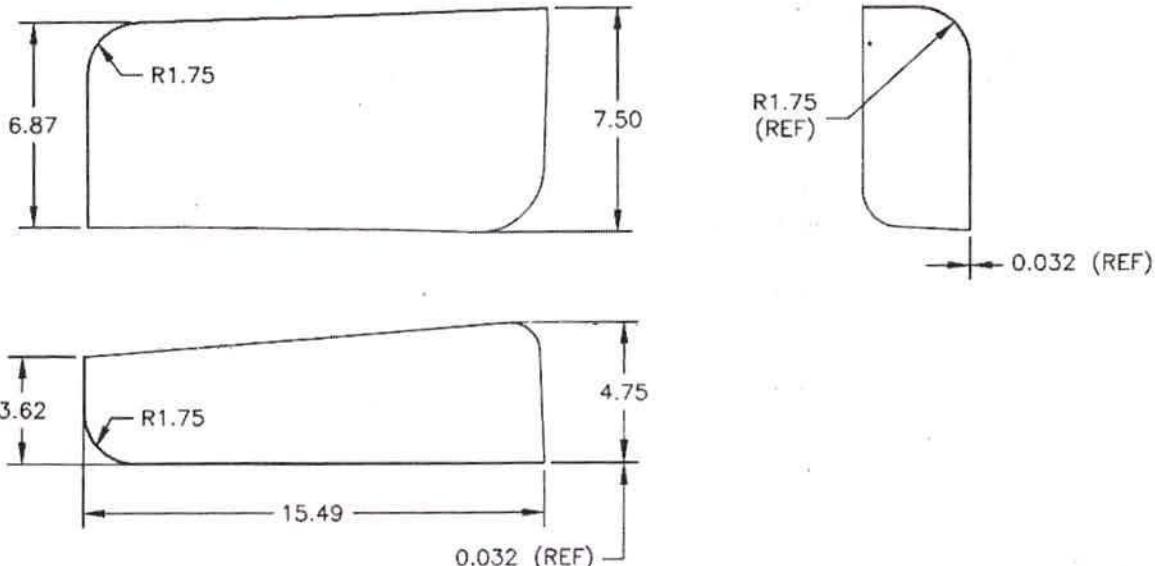
| | | | |
|----------------------|--------------------------------|---|------------------------|
| DESIGN <i>PF</i> | DRAWN BY <i>HF</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>IP</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D3255 | REV. B SHEET 1 OF 4 |
| DATE 04.12.06 | | TITLE ACCESS PANEL ASSEMBLY | SCALE 1:6 |
| A | 04.01.27 | NEW ISSUE | |
| B | 04.12.06 | D3255-3 REDESIGN; ADDED Ø0.098 | |

RELEASED
05-01-18 *f*

WELD D3255-3



**D3255-041 ACCESS PANEL (SHOWN)
D3255-042 ACCESS PANEL (OPPOSITE)**



**D3255-1 BEND DETAIL
D3255-2 OPPOSITE**

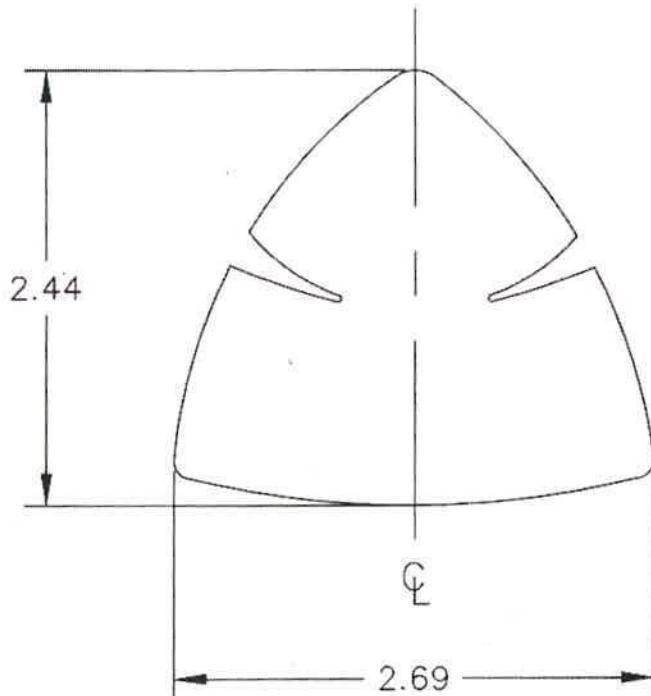
D3255-041/-042 NOTES:

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
- 3) INSTALL D3255-5 GASKET USING DOW CORNING P/N 736 ADHESIVE IN ACCORDANCE WITH MANUFACTURE'S INSTRUCTIONS
- 4) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER

DART

| | | | |
|------------------|---------------------------|---|------------------------|
| DESIGN PF | DRAWN BY PF | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED P | APPROVED PF | DRAWING NO. D3255 | REV. B SHEET 2 OF 4 |
| DATE 04.12.06 | | TITLE TITLE | SCALE 1:1 |

RELEASED
05-01-18 ~~PF~~



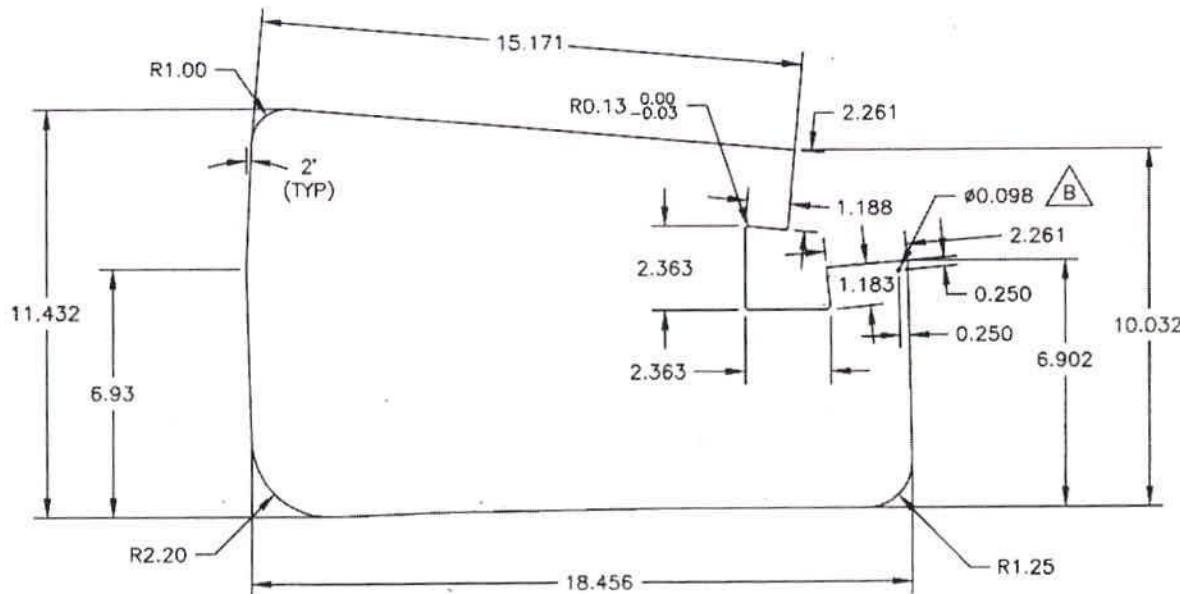
D3255-3 CAP
FORM TO FIT D3155-1/-2

D3255-3 NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) MAKE PER DRAWING "D3255-B2.DWG"

DART

| | | | | |
|----------------------|-----------------------|---|--------------|--------------|
| DESIGN <i>PF</i> | DRAWN BY <i>FF</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | | |
| CHECKED <i>IP</i> | APPROVED <i>HF</i> | DRAWING NO. D3255 | REV. B | SHEET 3 OF 4 |
| DATE 04.12.06 | | TITLE ACCESS PANEL ASSEMBLY | SCALE 1:5 | |

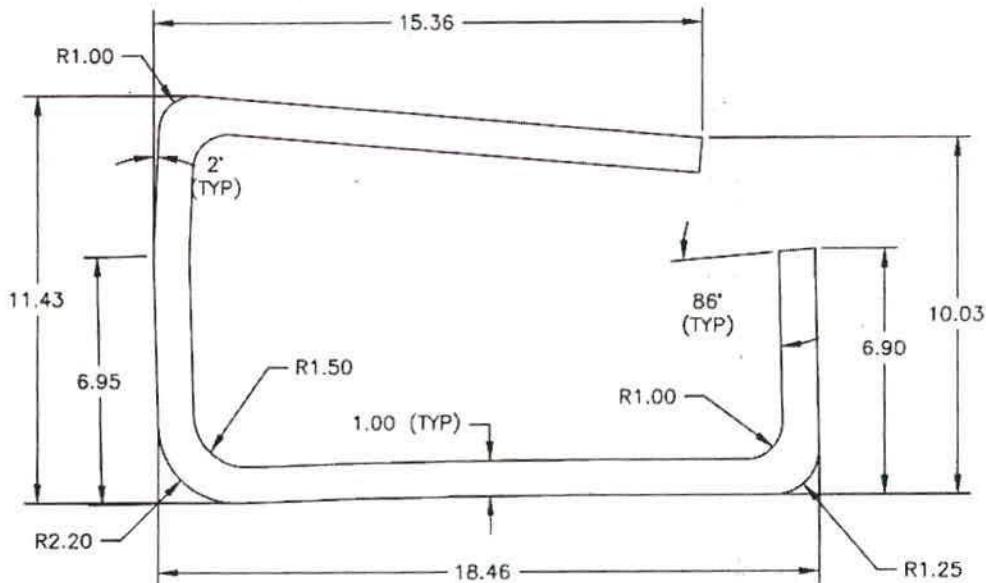
RELEASED
05-01-18**D3255-1/-2 FLAT PATTERN****D3255-1/-2 NOTES:**

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

DART

| | | | |
|----------------------|-----------------------|---|------------------------|
| DESIGN <i>TT</i> | DRAWN BY <i>TT</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>IP</i> | APPROVED <i>TT</i> | DRAWING NO. D3255 | REV. B SHEET 4 OF 4 |
| DATE 04.12.06 | | TITLE ACCESS PANEL ASSEMBLY | SCALE 1:5 |

RELEASED
05.01.18 *#*

D3255-5 GASKETD3255-5 NOTES:

- 1) MATERIAL: SILICONE COATED FIBERGLASS CLOTH PER AMS 3320F
P/N SIL/F 36x36x1/16
POSSIBLE SUPPLIER: AVIALL
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES